

Date: Friday, 23/05/2008 12:41:39 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LABEL PLATE		
Job Number	: 39457					
Estimate Number	: 10599					
P.O. Number	:			Part Number	: D2506	
This Issue	: 23/05/2008		S.O. No.	: D2506 REV E		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 37446			Drawing Revision	: E	
Written By	:			Material	:	
Checked & Approved By	: JUD 08.5.23			Due Date	: 06/06/2008	
Comment	: Est. B 01.06.08 Now laser cut EC est C 06.12.13 ecn 822 ec			Qty:	25	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		39
		Comment: Qty.: 1.2810 sf(s)/Unit Total : 32.0250 sf(s) 304/316 .040 Sheet Batch: 108156 13 8-5-28
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D Dwg Rev: F Prog Rev: E
		13 8-5-28
		2-Deburr if necessary 13 8-5-28
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		13 8-5-28
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		13 08/05/27 430 creates
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Done at step 22 13 08/05/27
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 39457

Part Number: D2506

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2506

SB 08/06/03 (30)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counted

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAT Dual

AS 08/06/05 (70)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/06/05 (70)

Job Completion



MF 08-06-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	3945+
Description: Label Plate	Part Number:	D2506
Inspection Dwg: D2506	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

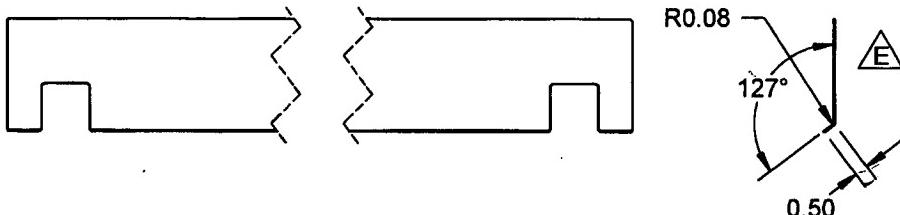
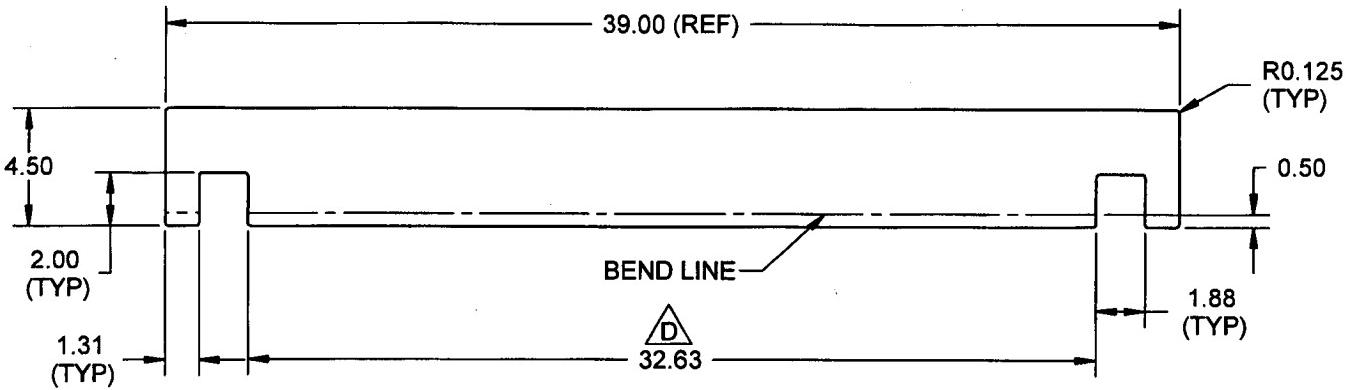
Measured by:	HB	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	8-5-29	Date:	09/05/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	
B	06.12.20	Dwg Rev. updated	KJ/JLM	
C	07.09.06	0.040 dimension added	KJ/JLM	Z

DART

DESIGN BW	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>HH</i>	DRAWING NO. D2506
DATE 06.11.20	TITLE LABEL PLATE	SCALE 1:7
REV	DATE	DESCRIPTION
A	95.11.26	NEW ISSUE
B	96.06.18	RE-DESIGN OF LABEL PLATE
C	96.09.04	RE-DESIGN OF LABEL PLATE
D	99.10.04	32.63 WAS 32.25; 1.31 WAS 1.50
E	06.11.20	REMOVE 10° BEND; ADD NOTES: 127° WAS 126°

RELEASED

06.11.28 *HH*

E

NOTES:

- 1) MATERIAL: STAINLESS STEEL AISI 304/316 SHEET 0.040 THICK PER MIL-S-5019
(REF DART SPEC M304S20GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY

RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

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